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APPLICATION FOR UNITED STATES LETTERS PATENT

for

**Modified Tubular Equipped With a Tilted or Transverse  
Magnetic Dipole for Downhole Logging**

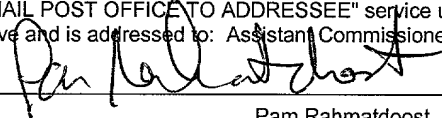
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# MODIFIED TUBULAR EQUIPPED WITH A TILTED OR TRANSVERSE MAGNETIC DIPOLE FOR DOWNHOLE LOGGING

## Cross-reference to related applications

5 This application is a continuation-in-part of U.S. Patent Application Serial No. 09/576,271, filed May 22, 2000.

## 1. BACKGROUND OF THE INVENTION

### 1.1 Field of the Invention

10 This invention relates generally to the investigation of subsurface earth formations, and, more particularly, to techniques for determining formation properties using tilted or transverse magnetic dipole sources or sensors housed within a modified metallic tubular. This invention is applicable to induction or propagation type measurements, i.e., at low and high frequencies.

### 1.2 Description of Related Art

15 Resistivity and gamma-ray logging are the two formation evaluation measurements run most often in well logging. Such measurements are used to locate and evaluate the properties of potential hydrocarbon bearing zones in subsurface formations. In many wells, they are the only two measurements performed, particularly in low cost wells and in surface and intermediate sections of more expensive wells.

20 These logging techniques are realized in different ways. A well tool, comprising a number of transmitting and detecting devices for measuring various parameters, can be lowered into a borehole on the end of a cable, or wireline. The cable, which is attached to some sort of mobile processing center at the surface, is the means by which parameter data is sent up to the surface. With this type of wireline logging, it becomes possible to measure borehole and formation parameters as a function of depth, i.e., while the tool is being pulled uphole.

25 Some wells may not be logged because wireline logging is too expensive, when rig time is included in the total cost. Conditioning the well for wireline logging, rigging up the

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wireline tools, and the time to run the wireline tools in and out require rig time. Horizontal or deviated wells also present increased cost and difficulty for the use of wireline tools.

Other wells present a challenge for wireline conveyance. Wells with extremely rugose, washed out, collapsed, or deviated boreholes can hinder or prevent the well tool from traveling through the borehole. These tough logging conditions (TLC) are typically handled by conveying the tool into the borehole on drillpipe. The instruments are mounted on drillpipe and tripped down into the open hole section. The wireline is protected inside the drillpipe in the open hole section of the well but lies between the drillpipe and the casing running to the surface, where it is prone to damage. Another disadvantage of this technique is that wireline power and communication are required while pushing the tool into the open hole section in order to avoid breaking the tool if an obstruction is encountered. Because of the danger of tool and wireline damage, logging is slow.

An alternative to wireline logging techniques is the collection of data on downhole conditions during the drilling process. By collecting and processing such information during the drilling process, the driller can modify or correct key steps of the operation to optimize performance. Schemes for collecting data of downhole conditions and movement of the drilling assembly during the drilling operation are known as Measurement While Drilling (MWD) techniques. Similar techniques focusing more on measurement of formation parameters than on movement of the drilling assembly are known as Logging While Drilling (LWD). As with wireline logging, the use of LWD and MWD tools may not be justified due to the cost of the equipment and the associated service since the tools are in the hole for the entire time it takes to drill the section.

Logging While Tripping (LWT) presents a cost-effective alternative to LWD and MWD techniques. In LWT, a small diameter "run-in" tool is sent downhole through the drill pipe, at the end of a bit run, just before the drill pipe is pulled. The run-in tool is used to measure the downhole physical quantities as the drill string is extracted or tripped out of the hole. Measured data is recorded into tool memory versus time during the trip out. At the surface, a second set of equipment records bit depth versus time for the trip out, and this allows the measurements to be placed on depth.

U.S. Pat. No. 5,589,825 describes a LWT technique incorporating a logging tool adapted for movement through a drillstring and into a drilling sub. The '825 patent describes a sub incorporating a window mechanism to permit signal communication between a housed logging tool and the wellbore. The window mechanism is operable between an open and closed position. A disadvantage of the proposed apparatus is that the open-window mechanism directly exposes the logging tool to the rugose and abrasive borehole environment, where formation cuttings are likely to damage the logging tool and jam the window mechanism. Downhole conditions progressively become more hostile at greater depths. At depths of 5,000 to 8,000 meters, bottom hole temperatures of 260°C and pressures of 170 Mpa are often encountered. This exacerbates degradation of external or exposed logging tool components. Thus, an open-window structure is impractical for use in these situations.

UK Patent Application GB 2337546A describes a composite structure incorporated within a drill collar to permit the passage of electromagnetic energy (EM) for use in measurements during the drilling operation. The '546 application describes a drill collar having voids or recesses with embedded composite covers. A disadvantage of the apparatus proposed by the '546 application is the use of composite materials as an integral part of the drill collar. Fatigue loading (i.e., the bending and rotating of the drill pipe) becomes an issue in drilling operations. When the drill pipe is subjected to bending or torsion, the shapes of the voids or recesses change, resulting in stress failure and poor sealing. The differences in material properties between the metal and composite covers are difficult to manage properly where the composite and metal are required to act mechanically as one piece, such as described in the '546 application. Thus, the increased propensity for failure under the extreme stresses and loading encountered during drilling operations makes implementation of the described structure impractical.

U.S. Pat. Nos. 5,988,300 and 5,944,124 describe a composite tube structure adapted for use in a drillstring. The '300 and '124 patents describe a piecewise structure including a composite tube assembled with end-fittings and an outer wrapping connecting the tube with the end-fittings. In addition to high manufacturing costs, another disadvantage of this

structure is that the multi-part assembly is more prone to failure under the extreme stresses encountered during drilling operations.

U.S. Pat. No. 5,939,885 describes a well logging apparatus including a mounting member equipped with coil antennas and housed within a slotted drill collar. However, the apparatus is not designed for LWT operations. U.S. Pat. Nos. 4,041,780 and 4,047,430 describe a logging instrument that is pumped down into a drill pipe for obtaining logging samples. However, the system proposed by the '780 and '430 patents requires the withdrawal of the entire drill string (for removal of the drill bit) before any logging may be commenced. Thus, implementation of the described system is impractical and not cost effective for many operations.

U.S. Pat. No. 5,560,437 describes a telemetry method and apparatus for obtaining measurements of downhole parameters. The '437 patent describes a logging probe that is ejected into the drill string. The logging probe includes a sensor at one end that is positioned through an aperture in a special drill bit at the end of the drill string. As such, the sensor has direct access to the drill bore. Disadvantages of the apparatus proposed by the '437 patent are the sensor's direct exposure to the damaging conditions encountered downhole and the requirement of an unobstructed path in the drillstring for the probe to travel, which is incompatible with drillstrings containing a mud-pulse telemetry tool or a mud motor. The use of a small probe protruding through a small aperture is also impractical for resistivity logging.

U.S. Pat. No. 4,914,637 describes a downhole tool adapted for deployment from the surface through the drill string to a desired location in the conduit. A modulator on the tool transmits gathered signal data to the surface. U.S. Pat. No. 5,050,675 (assigned to the present assignee) describes a perforating apparatus incorporating an inductive coupler configuration for signal communication between the surface and the downhole tool. U.S. Pat. No. 5,455,573 describes an inductive coupling device for coaxially arranged downhole tools. U.S. Pat. No. 6,288,548 describes a while-drilling logging technique using a measurement sonde disposed within a drill collar implemented with slots.

Conventional logging tools are implemented with transmitter and receiver arrays consisting of a set of coil antennas mounted on a support and axially spaced from each other

in the direction of the borehole. A coil carrying a current can be represented as a magnetic dipole having a magnetic moment proportional to the current and the area encompassed by the coil. The direction and strength of the magnetic dipole moment can be represented by a vector perpendicular to the area encompassed by the coil. Typical logging tools are equipped with coils of the cylindrical solenoid type comprised of one or more turns of insulated conductor wire. Some tools are also implemented with saddle coil or flex circuit antenna configurations.

In conventional induction and propagation logging systems, the transmitter and receiver antennas are generally mounted with their axes parallel to the longitudinal axis of the support or mandrel. Thus, these tools are implemented with antennas having longitudinal magnetic dipoles (LMD).

An emerging technique in the field of well logging is the use of tools incorporating antennas having tilted or transverse coils, i.e., where the coil's axis is not parallel to the longitudinal axis of the support. These tools are thus implemented with antennas having a transverse or tilted magnetic dipole (TMD). One particular implementation uses a set of three antennas having non-parallel axes (referred to herein as tri-axial). The aim of these TMD configurations is to provide EM measurements with directional sensitivity to the formation properties, including information about resistivity anisotropy in vertical wells and directional sensitivity to bed boundaries that can be used for navigation. Logging instruments equipped with TMDs are described in U.S. Pat. Nos. 6,163,155, 6,147,496, 5,757,191, 5,115,198, 4,319,191, 5,508,616, 5,757,191, 5,781,436, 6,044,325, 4,264,862 and 6,147,496.

It is desirable to have a simplified technique for determining formation properties using instruments equipped with TMDs. Thus there remains a need for a versatile logging apparatus capable of providing reliable measurements in LWT, LWD, or TLC operations.

## 2. SUMMARY OF THE INVENTION

The invention provides an apparatus for determining a property of a subsurface formation. The apparatus comprises an elongated body with tubular walls and a central bore, the body including at least one slot formed therein such that the slot fully penetrates the tubular wall; a support having a longitudinal axis, said support disposed within said central

bore; and at least one antenna disposed on the support, said antenna being adapted to generate a magnetic dipole moment with a transverse or controllable orientation; wherein said antenna is positioned near the at least one slot.

The invention provides a method for determining a property of a subsurface formation. The method comprises disposing an elongated body within a borehole traversing said formation, said body having tubular walls, a central bore, and including at least one slot formed therein such that the slot fully penetrates the tubular wall; disposing a support within the central bore of said body, said support having a longitudinal axis and at least one antenna disposed thereon, said antenna being adapted to generate a magnetic dipole moment with a transverse or controllable orientation; positioning said antenna near the at least one slot on said body; and transmitting or receiving a signal with said at least one antenna to determine said formation property.

The invention provides a system for determining a property of a subsurface formation. The system comprises a sub having an elongated body with tubular walls and a central bore, the sub being adapted to form a portion of a length of drill string; the sub having at least one slot formed therein such that the slot fully penetrates the tubular wall; a support member having at least one antenna disposed thereon, said antenna being adapted to generate a magnetic dipole moment with a transverse or controllable orientation; the support member being adapted for transit through the drill string and into the central bore of the sub; and means for receiving the support member within the sub.

### 3. BRIEF DESCRIPTION OF THE DRAWINGS

Other aspects and advantages of the invention will become apparent upon reading the following detailed description and upon reference to the drawings in which:

Figure 1 is a schematic diagram of a run-in tool in accord with the invention.

Figure 2a is a cross-sectional view of a run-in tool showing an antenna with associated wiring and passages in accord with the invention.

Figure 2b is a schematic diagram of a shield structure surrounding an antenna on the run-in tool in accord with the invention.

Figure 3 is a schematic diagram of a tubular member with slotted stations in accord with the invention.

Figures 4a and 4b are schematic diagrams of a run-in tool engaged within a tubular member in accord with the invention.

Figure 5 graphically illustrates the relationship between the slot dimensions of a tubular segment of the invention and the attenuation of passing electromagnetic energy.

Figure 6 is a schematic diagram of a run-in tool with a centralizer configuration in accord with the invention.

Figure 7a is a cross-sectional view of a tubular member with a pressure barrier configuration in accord with the invention.

Figure 7b is a cross-sectional view of a three-slotted tubular member of Figure 7a along line A-A.

Figure 8a is a cross-sectional view of a tubular member with another pressure barrier configuration in accord with the invention.

Figure 8b is a cross-sectional view of a three-slotted tubular member of Figure 8a along line B-B.

Figure 9a is a cross-sectional view of a run-in tool positioned in alignment with a pressure barrier configuration in accord with the invention.

Figure 9b is a top view of the run-in tool and pressure barrier configuration of Figure 9a.

Figure 10 is a cross-sectional view of a pressure barrier and tubular member configuration in accord with the invention.

Figure 11 is a cross-sectional view of a slotted tubular member with an insert, seal, and retaining sleeve in accord with the invention.

Figures 12a and 12b are cross-sectional views and cut-away perspectives of a slotted tubular station with a tapered slot and a corresponding tapered insert in accord with the invention.

Figure 13a is a schematic diagram of a run-in tool and antenna eccentered within a tubular member in accord with the invention.



Figures 13b and 13c are schematic diagrams of a run-in tool and antenna surrounded by a focusing shield and respectively showing the shield's effect on the magnetic and electric fields in accord with the invention.

Figure 14 is a top view of a shielding structure formed within the bore of the tubular member in accord with the invention.

Figure 15 is a schematic diagram of a shielding structure formed by a cavity within the run-in tool in accord with the invention.

Figure 16 is a schematic diagram of a run-in tool including a modulator engaged within a tubular member in accord with the invention.

Figure 17 is a schematic diagram of the run-in tool configuration of Figure 16 as used for real-time wireless communication with a remote downhole tool in accord with invention.

Figure 18 is a schematic diagram of a run-in tool configuration for porosity measurements utilizing magnetic nuclear resonance techniques in accord with the invention.

Figures 19a and 19b are schematic diagrams of run-in tool antenna configurations within tubular members in accord with the invention.

Figure 20 shows schematic diagrams of a tubular member and run-in tool configuration with inductive couplers in accord with the invention.

Figure 21 shows a top view and a schematic diagram and of an eccentric run-in tool and tubular member with inductive couplers in accord with the invention.

Figures 22a and 22b are schematic diagrams of an inductive coupler configuration within a run-in tool and tubular member in accord with the invention.

Figure 23 is a cross-sectional view of an inductive coupler and shield configuration mounted within a tubular member in accord with the invention.

Figure 24 is a schematic diagram of a simplified inductive coupler circuit in accord with the invention.

Figure 25 is a flow chart illustrating a method for transmitting and/or receiving a signal through an earth formation in accord with the invention.

Figure 26 is a flow chart illustrating a method for measuring a characteristic of an earth formation surrounding a borehole in accord with the invention.

Figure 27 is a flow chart illustrating a method for sealing an opening on the surface of a tubular member in accord with the invention.

Figure 28 is a flow chart illustrating a method for sealing a fully penetrating opening on a surface of a tubular member in accord with the invention.

5 Figure 29 is a schematic diagram of a run-in tool eccentered within a tubular in accord with the invention.

Figure 30 is a schematic diagram of a run-in tool equipped with a TMD antenna in accord with the invention.

Figure 31 illustrates the wiring scheme of the antenna of Figure 30.

10 Figure 32 shows a magnetic dipole orientation of the antenna of Figure 31.

Figures 33a-33c illustrate antenna configurations in accord with the invention.

Figure 34 is a schematic diagram and an overhead view of a slotted tubular implemented with a TMD antenna in accord with the invention.

15 Figure 35 is another schematic diagram and an overhead view of a slotted tubular implemented with a TMD antenna in accord with the invention.

Figure 36 graphically illustrates the relationship between magnetic field distortion and specific slot widths near the tubular of the invention.

Figure 37 graphically illustrates the EM field rotation from a TMD antenna with and without a tubular of the invention.

20 Figure 38 is a schematic diagram of a TMD-equipped run-in tool/tubular of the invention.

Figure 39 is another schematic diagram of a TMD-equipped run-in tool/tubular of the invention.

25 Figure 40 is a flow chart illustrating a method for determining a property of a subsurface formation in accord with the invention.

Figure 41a is an overhead view of a run-in tool/tubular configuration in accord with the invention.

Figure 41b is a schematic diagram of the run-in tool/tubular configuration of Figure 41a.

30 Figure 41c is a schematic diagram of the tubular configuration of Figure 41b.

#### 4. DETAILED DESCRIPTION

The apparatus of the invention consists of two main assets, a run-in tool (RIT) and a tubular sleeve or drill collar. Henceforth, the tubular will be referred to as a sub.

##### 4.1 RIT

Figure 1 shows an embodiment of the RIT 10 of the invention. The RIT 10 is an elongated, small-diameter, metallic support or mandrel that may contain one or more antennas 12, sources, sensors [sensor/detector are interchangeable terms as used herein], magnets, a gamma-ray detector/generator assembly, neutron-generating/detecting assembly, various electronics, batteries, a downhole processor, a clock, a read-out port, and recording memory (not shown).

The RIT 10 does not have the mechanical requirements of a drill collar. Thus, its mechanical constraints are greatly reduced. The RIT 10 has a landing mechanism (stinger) 14 on the bottom end and a fishing head 16 on the top. The fishing head 16 allows for the RIT 10 to be captured and retrieved from within a sub with the use of a conventional extraction tool such as the one described in U.S. Pat. No. 5,278,550 (assigned to the present assignee). An advantage of the fishable RIT 10 assembly is a reduction of Lost-In-Hole costs. The RIT 10 may also be implemented with one or more articulated or “knuckle” joints as known in the art (see Figure 29).

As shown in Figure 2a, one antenna 12 configuration on the RIT 10 consists of multi-turn wire loops encased in fiberglass-epoxy 18 mounted in a groove in the RIT 10 pressure housing and sealed with rubber over-molding 20. A feed-through 22 provides a passage for the antenna 12 wiring, leading to an inner bore 24 within the RIT 10. Each antenna 12 may be activated to receive or transmit an EM signal as known in the art.

The antennas 12 radiate an azimuthal electric field. Each antenna 12 is preferably surrounded by a stainless-steel shield 26 (similar to those described in U.S. Pat. No. 4,949,045, assigned to the present assignee) that has one or more axial slots 28 arrayed around the shield 26 circumference. Figure 2b shows the axial slots 28 distributed around the circumference of the shield 26. The shields 26 are short-circuited at the axial ends into the metallic body of the RIT 10. These shields 26 permit transverse electric (TE) radiation to propagate through while blocking transverse magnetic (TM) and transverse electromagnetic

(TEM) radiation. The shields 26 also protect the antennas 12 from external damage. The RIT 10 electronics and sensor architecture resembles that described in U.S. Pat. No. 4,899,112 (assigned to the present assignee).

## 4.2 Sub

Figure 3 shows an embodiment of a sub 30 of the invention. The sub 30 has an elongated body with tubular walls and a central bore 32. The sub 30 contains neither electronics nor sensors and is preferably fully metallic, preferably formed from stainless steel. It may form part of the normal bottom hole assembly (BHA), and it may be placed in the hole with the drill string for the duration of the bit run. One embodiment of the sub 30 has normal threaded oilfield connections (pin and box) at each end (not shown). The sub 30 may also be coupled to coiled tubing or to other tubular segments for conveyance into the wellbore in TLC operations.

The sub 30 includes one or more stations 36 with one or more axial slots 38 placed along the tubular wall. Each elongated axial slot 38 fully penetrates the tubular wall of the sub 30 and is preferably formed with fully rounded ends. Stress modeling has shown that rather long slots 38 may be formed in the sub 30 walls while still maintaining the structural integrity of the sub 30. Stress relief grooves 40 may be added to the OD of the sub 30, in regions away from the slot(s) 38, to minimize the bending moment on the slot(s) 38.

Each slot 38 provides a continuous channel for EM energy to pass through the sub 30. The slots 38 block TM radiation but allow the passage of TE radiation, albeit with some attenuation. The degree of attenuation of TE fields by the sub 30 depends on factors such as frequency, the number of slots, slot width, slot length, collar OD and ID, and the location and dimensions of the RIT 10 antenna. For example, Figure 5 shows the sub 10 attenuation measured at 400 kHz with a 25-turn 1.75-inch diameter coil centered in 3.55-inch ID, 6.75-inch OD subs 30 with one or two slots 38 of different lengths and widths. As evident from Figure 5, adding more slots 38 and making the slots longer or wider decreases the attenuation. However, with only one or two 0.5-inch wide 6-8 inch long slots 38, the sub 30 attenuation is already ~15 dB, which is sufficiently low for many applications.

In operation, one embodiment of the RIT 10 is pumped down and/or lowered through the drillstring on cable at the end of the bit run and engaged inside the sub 30. The RIT 10 is received by a landing "shoe" 42 within the central bore 32 of the sub 30, as shown in Figure 4a. Figure 4b shows how the RIT 10 is located in the sub 30 so that each antenna 12, source, or sensor, is aligned with a slot 38 in the sub 30. The landing shoe 42 preferably also has a latching action to prevent any axial motion of the RIT 10 once it is engaged inside the sub 30.

Turning to Figure 6, an embodiment of the invention includes a centralizer 44, which serves to keep the RIT 10 centered and stable within the sub 30, lowering shock levels and reducing the effects of tool motion on the measurement. One or more centralizers 44 may be mounted within the central bore 32 to constrain the RIT 10 and keep it from hitting the ID of the sub 30. One or more spring-blades 46 may also be mounted to extend from the centralizer 44 to provide positioning stability for the RIT 10. The spring-blades 46 are compressed against the RIT 10 when it is engaged within the sub 30. Bolts 48 with O-ring seals 50 may be used to hold the centralizer(s) 44 in the sub 30 while preserving the pressure barrier between the ID and the OD of the sub 30.

Alternatively, the centralizer 44 may be mounted on the RIT 10 rather than on the sub 30 (See Figure 16). In this case, the centralizer 44 may be configured to remain in a retracted mode during the trip down, and to open when the RIT 10 lands in the sub 30. It will be understood that other centralizer 44 configurations may be implemented with the invention as known in the art.

The RIT 10 and sub 30 have EM properties similar to a coaxial cable, with the RIT 10 acting as the inner conductor, and the sub 30 acting as the outer conductor of a coaxial cable. If the drilling mud is conductive, then the "coax" is lossy. If the drilling mud is oil based, the "coax" will have little attenuation. Parasitic antenna 12 coupling may take place inside of the sub 30 between receiver-receiver or transmitter-receiver. As described above, the shields 26 surrounding the antennas 12 are grounded to the mandrel of the RIT 10 to minimize capacitive and TEM coupling between them. Electrically balancing the antennas 12 also provides for TEM coupling rejection. The centralizers 44 may also be used as a means of contact to provide radio-frequency (rf) short-circuits between the RIT 10 and the sub 30 to

prevent parasitic coupling. For example, small wheels with sharp teeth may be mounted on the centralizers 44 to ensure a hard short between the RIT 10 and the sub 30 (not shown).

### 4.3 Pressure Barrier

Since each slot 38 fully penetrates the wall of the sub 30, an insulating pressure barrier is used to maintain the differential pressure between the inside and the outside of the sub 30 and to maintain hydraulic integrity. There are a variety of methods for establishing a pressure barrier between the sub 30 ID and OD at the slotted station 36.

Turning to Figure 7a, an embodiment of a sub 30 with a pressure barrier of the invention is shown. A cylindrical sleeve 52 is positioned within the central bore 32 of the sub 30 in alignment with the slot(s) 38. The sleeve 52 is formed of a material that provides transparency to EM energy. Useable materials include the class of polyetherketones described in U.S. Pat. No. 4,320,224, or other suitable resins. *Victrex USA, Inc.* of West Chester, PA manufactures one type called PEEK. Another usable compound is known as PEK. *Cytec Fiberite, Greene Tweed*, and *BASF* market other suitable thermoplastic resin materials. U.S. Pat. No. 6,300,762 (assigned to the present assignee) describes a class of polyaryletherketone-based materials that may be used to implement the invention. Another useable material is Tetragonal Phase Zirconia ceramic (TZP), manufactured by *Coors Ceramics*, of Golden, Colorado. It will be appreciated by those skilled in the art that these and other materials may be combined to form a useable sleeve 52.

PEK and PEEK can withstand substantial pressure loading and have been used for harsh downhole conditions. Ceramics can withstand substantially higher loads, but they are not particularly tolerant to shock. Compositions of wound PEEK or PEK and glass, carbon, or KEVLAR may also be used to enhance the strength of the sleeve 52.

A retainer 54 and spacer 56 are included within the central bore 32 to support the sleeve 52 and provide for displacement and alignment with the slots 38. The sleeve 52 is positioned between the retainer 54 and spacer 56, which are formed as hollow cylinders to fit coaxially within the central bore 32. Both are preferably made of stainless steel. The retainer 54 is connected to the sleeve 52 at one end, with the sleeve 52 fitting coaxially inside the retainer 54. As the differential pressure increases within the ID of the sub 30 during

operation, the sleeve 52 takes the loading, isolating the sub 30 from the pressure in the slotted region. Hydraulic integrity is maintained at the junction between the sleeve 52 and retainer 54 by an O-ring seal 53. A fitted "key" 55 is used to engage the sleeve 52 to the retainer 54, preventing one from rotating relative to the other (See Figure 7a blow-up). An index pin 57 is fitted through the sub 30 and engaged to the free end of the retainer 54 to prevent the retainer from rotating within the bore 32 of the sub 30. O-rings 59 are also placed within grooves on the OD of the retainer 54 to provide a hydraulic seal between the retainer 54 and the sub 30.

In operation, the internal sleeve 52 will likely undergo axial thermal expansion due to high downhole temperatures. Thus, it is preferable for the sleeve 52 to be capable of axial movement as it undergoes these changes in order to prevent buckling. The spacer 56 consists of an inner cylinder 60 within an outer cylinder 62. A spring 64 at one end of the OD of the inner cylinder 60 provides an axial force against the outer cylinder 62 (analogous to an automotive shock absorber). The outer cylinder 62 is connected to the sleeve 52 using the key 55 and O-ring seal 53 at the junction as described above and shown in the blow-up in Figure 7a. The spring-loaded spacer 56 accounts for differential thermal expansion of the components. The sub 30 embodiment of Figure 7a is shown connected to other tubular members by threaded oilfield connections 70.

For purposes of illustration, a sub 30 with only one slot 38 is shown in Figure 7a. Other embodiments may include several sleeves 52 interconnected in the described manner to provide individual pressure barriers over multiple slotted stations 36 (not shown). With this configuration, only two O-ring 53 seals to the ID of the sub 30 are used over the entire slotted array section. This minimizes the risk involved with dragging the O-rings 53 over the slots 38 during assembly or repair. Figure 7b shows a cross-section of the sub 30 (along line A-A of Figure 7a) with a three-slot 38 configuration.

Figure 8a shows another embodiment of a sub 30 with a pressure barrier of the invention. In this embodiment, the spring-loaded spacer 62 maintains the outer cylinder 62 abutted against the sleeve 52 and O-rings 68 are placed within grooves on the OD of the sleeve 52, preferably at both ends of the slot 38. The retainer 54 rests at one end against a

shoulder or tab 58 formed on the wall of the central bore 32. Figure 8b shows a cross-section of the sub 30 (along line B-B of Figure 8a) with a three-slot 38 configuration.

In another embodiment of a pressure barrier of the invention, a sleeve 52 made out of PEEK or PEK, or glass, carbon, or KEVLAR filled versions of these materials, may be bonded to a metal insert (not shown), where the insert contains O-rings to seal against the sub 30 as described above. The metal insert could be mounted within the sub 30 as described above or with the use of fastener means or locking pins (not shown). The sleeve material may also be molded or wrapped onto the supporting insert. The fibers in the wrapped material can also be aligned to provide additional strength.

Figure 9a shows another embodiment of a pressure barrier of the invention. In this embodiment, the cylindrical sleeve 52 is held in alignment with the slot(s) 38 by a metal retainer 72. The retainer 72 may be formed as a single piece with an appropriate slot 74 cut into it for signal passage as shown, or as independent pieces supporting the sleeve 52 at the top and bottom (not shown). The retainer 72 may be constrained from axial movement or rotation within the sub 30 by any of several means known in the art, including an index-pin mechanism or a keyed-jam-nut type arrangement (not shown). The slot 38 may also be filled with a protective insert as will be further described below. In operation, a RIT 10 is positioned within the sub 30 such that the antenna 12 is aligned with the slot(s) 38.

As shown in Figure 9b, the retainer 72 is formed such that it extends into and reduces the ID of the sub 30 to constrain the RIT 10. Mudflow occurs through several channels or openings 76 in the retainer 72 and through the annulus 78 between the RIT 10 and the retainer 72. The retainer 72 in effect acts as a centralizer to stabilize the RIT 10 and to keep it from hitting the ID of the sub 30, lowering shock levels and increasing reliability.

Figure 10 shows another embodiment of a pressure barrier of the invention. A sub 30 may be formed with a shop joint 80 so that the sleeve 52 can be inserted within the central bore 32. The sleeve 52 is formed as described above and provides a hydraulic seal using O-rings 82 within grooves at both ends on the OD of the sleeve 52. The sleeve 52 is restrained from axial movement within the central bore 32 by a lip 84 formed on one end of the two-piece sub 30 and by the end of the matching sub 30 joint. Since the sleeve 52 sits flush within a recess 86 in the ID of the sub 30, this configuration offers unrestricted passage to a



large diameter RIT 10. This configuration also provides easy access to the sleeve 52 and slot(s) 38 for maintenance and inspection.

Turning to Figure 11, another embodiment of a pressure barrier of the invention is shown. The slot 38 in the sub 30 is three-stepped, preferably with fully rounded ends. One of the steps provides a bearing shoulder 90 for an insert 92, and the other two surfaces form the geometry for an O-ring groove 94 in conjunction with the insert 92. A modified O-ring seal consists of an O-ring 96 stretched around the insert 92 at the appropriate step, with metal elements 98 placed on opposite sides of the O-ring 96. The metal elements 98 are preferably in the form of closed loops.

The sleeve 52 may be fitted within the sub 30 with one or more O-rings (not shown) to improve hydraulic integrity as described above. As shown in Figure 11, the sleeve 52 may also have a slot 100 penetrating its wall to provide an unobstructed channel for any incoming or outgoing signal. The sleeve 52 may have a matching slot 100 for every slot 38 in the sub 30.

The insert 92 and sleeve 52 are preferably made of the dielectric materials described above to permit the passage of EM energy. However, if the sleeve 52 is configured with a slot 100, the sleeve 52 may be formed from any suitable material.

If the sleeve 52 is configured with a slot 100, the internal pressure of the sub 30 may push the insert 92 outward. The bearing shoulder 52 takes this load. As the internal pressure increases, the O-ring 96 pushes the metal elements 98 against an extrusion gap, which effectively closes off the gap. As a result, there is no room for extrusion of the O-ring 96. Since the metal is much harder than the O-ring material, it does not extrude at all. The modified geometry therefore creates a scenario where a soft element (the O-ring) provides the seal and a hard element (the metal loop) prevents extrusion, which is the ideal seal situation. In the event of pressure reversal, the sleeve 52 captures the insert 92 in the slot 38, preventing the insert 92 from being dislodged.

Other pressure barrier configurations may be implemented with the invention. One approach is the use of several individual sleeves 52 connected together by other retaining structures and restrained by a pressure-differential seal or a jam-nut arrangement (not shown). Another approach is the use of a long sleeve 52 to span multiple slotted stations 38 (not

shown). Still another approach is the use of a sleeve 52 affixed to the OD of the sub 30 over the slotted region, or a combination of an interior and exterior sleeve (discussed below).

#### 4.4 Slot Inserts

While the slotted stations of the invention are effective with fully open and unblocked slots 38, the operational life of the assembly may be extended by preventing debris and fluids from entering and eroding the slots 38 and the insulating sleeve 52. The slots 38 could be filled with rubber, an epoxy-fiberglass compound, or another suitable filler material to keep fluids and debris out while permitting signal passage.

An embodiment of a sub 30 with a tapered slot 38 is shown in Figure 12a. The slot 38 is tapered such that the outer opening  $W_1$  is narrower than the inner opening  $W_2$ , as shown in Figure 12b. A tapered wedge 88 of insulating material (e.g., fiberglass epoxy) is inserted within the tapered slot 38. The wedge 88 may be bonded into the sub 30 with rubber. The rubber layer surrounds the wedge 88 and bonds it into the sub 30. An annulus of rubber may also be molded on the interior and/or exterior surface of the sub 30 to seal the wedge 88 within the slot 38.

#### 4.5 Focusing Shield Structures

Measurements of the attenuation of the TE radiation from a simple coil-wound antenna 12 through a single slot 38 of reasonable dimensions show that the TE field is notably attenuated. This attenuation can be reduced, however, by using shielding around the antenna 12 to focus the EM fields into the slot 38.

Turning to Figure 13a, an antenna 12 consisting of 25 turns of wire on a 1.75-inch diameter bobbin was mounted on a 1-inch diameter metal RIT 10 and positioned fully eccentrically inside the bore of a 3.55-inch ID, 6.75-inch OD sub 30 against the slot 38 and centered vertically on the slot 38. The measured attenuation of the TE field between 25 kHz – 2 MHz was a nearly constant 16.5 dB.

Turning to Figure 13b, the same measurement was performed with the antenna 12 inside a thin shield 102 formed of a metallic tube with a 0.5-inch wide, 6-inch long slot 104

aligned with the slot 38 in the sub 30 (not shown). The antenna 12 was fully surrounded by the shield 102 except for the open slot 104 and placed inside the sub 30.

The attenuation with this assembly in the same sub 30 was 11.8 dB, a reduction of the attenuation of nearly 5 dB. Figures 13b and 13c respectively show how the shield 102 affects the magnetic and electric fields. The attenuation due to this shield 102 alone is minimal.

Figure 14 shows another embodiment of a shielding structure of the invention. In this embodiment, the central bore 32 of the sub 30 is configured with a bracket structure 106 that serves as a focusing shield by surrounding the antenna 12 when the RIT 10 is engaged within the sub 30.

Figure 15 shows another embodiment of a shielding structure of the invention. The mandrel of the RIT 10 has a machined pocket or cavity 108 in its body. A coil antenna 12 wound on a bobbin 110 made of dielectric material is mounted within the cavity 108. A ferrite rod may replace the dielectric bobbin 110. With this configuration, the body of the RIT 10 itself serves as a focusing shield. The hydraulic integrity of the RIT 10 is maintained by potting the antenna 12 with fiberglass-epoxy, rubber, or another suitable substance. The attenuation of a coil antenna 12 having 200 turns on a 0.875-inch diameter bobbin was measured for this assembly mounted the same way as described above in the same sub 30. The measured attenuation was only ~7 dB. It will be appreciated by those skilled in the art that other types of sources/sensors may be housed within the cavity 108 of the RIT 10.

#### 4.6 RIT / Sub Configurations

Figure 16 shows another embodiment of the invention. A sub 30 of the invention is connected to another tubular 111 forming a section of a drillstring. The RIT 10 includes an antenna 12, a stinger 14 at the lower end, and a fishing head 16 at the top end. The stinger 14 is received by the landing shoe 42 on the sub 30, which serves to align the antenna 12 with the slotted station 36. As above, the RIT 10 of this embodiment includes various electronics, batteries, a downhole processor, a clock, a read-out port, memory, etc. (not shown) in a pressure housing. The RIT 10 may also incorporate various types of sources/sensors as known in the art.

#### 4.6.1 RIT with Modulator

The RIT 10 of Figure 16 is also equipped with a modulator 116 for signal communication with the surface. As known in the art, a useable modulator 116 consists of a rotary valve that operates on a continuous pressure wave in the mud column. By changing the phase of the signal (frequency modulation) and detecting these changes, a signal can be transmitted between the surface and the RIT 10. With this configuration, one can send the RIT 10 through the drillstring to obtain measurement data (e.g., resistivity or gamma-ray counts) of formation characteristics and to communicate such data to the surface in real-time. Alternatively, all or some of the measurement data may be stored downhole in the RIT 10 memory for later retrieval. The modulator 116 may also be used to verify that the RIT 10 is correctly positioned in the sub 30, and that measurements are functioning properly. It will be appreciated by those skilled in the art that a modulator 116 assembly may be incorporated with all of the RIT/sub implementations of the invention.

Figure 17 shows another embodiment of the invention. The subs 30 and RITs 10 of the invention may be used to communicate data and/or instructions between the surface and a remote tool 112 located along the drill string. For purposes of illustration, the tool 112 is shown with a bit box 113 at the bottom portion of a drive shaft 114. The drive shaft 114 is connected to a drilling motor 115 via an internal transmission assembly (not shown) and a bearing section 117. The tool 112 also has an antenna 12 mounted on the bit box 113. The motor 115 rotates the shaft 114, which rotates the bit box 113, thus rotating the antenna 12 during drilling.

With the configuration of Figure 17, the RIT 10 may be engaged within the sub 30 at the surface or sent through the drill string when the sub 30 is at a desired downhole position. Once engaged, a wireless communication link may be established between the antenna 12 on the RIT 10 and the antenna 12 on the tool 112, with the signal passing through the slotted station 36. In this manner, real-time wireless communication between the surface and the downhole tool 112 may be established. It will be appreciated by those skilled in the art that other types of sensors and/or signal transmitting/receiving devices may be mounted on various types of remote tools 112 for communication with corresponding devices mounted on the RIT 10.

#### 4.6.2 Nuclear Magnetic Resonance Sensing

It is known that when an assembly of magnetic moments such as those of hydrogen nuclei are exposed to a static magnetic field they tend to align along the direction of the magnetic field, resulting in bulk magnetization. By measuring the amount of time for the hydrogen nuclei to realign their spin axes, a rapid nondestructive determination of porosity, movable fluid, and permeability of earth formations is obtained. See A. Timur, *Pulsed Nuclear Magnetic Resonance Studies of Porosity, Movable Fluid, and Permeability of Sandstones*, JOURNAL OF PETROLEUM TECHNOLOGY, June 1969, p. 775. U.S. Pat. No. 4,717,876 describes a nuclear magnetic resonance well logging instrument employing these techniques.

A determination of formation porosity from magnetic resonance may be obtained with a non-magnetic sub 30 of the invention as shown in Figure 18. The sub 30 can be formed of the typical high-strength non-magnetic steel used in the industry. The RIT 10 contains the electronics, batteries, CPU, memory, etc., as described above. Opposing permanent magnets 118 contained in the RIT 10 provide the magnetic field. A rf coil 120 is mounted between the magnets 118 for generating a magnetic field in the same region to excite nuclei of the formation vicinity. The design of the rf coil 120 is similar to the antennas 12 described above in being a multi-turn loop antenna with a central tube for through wires and mechanical strength. The permanent magnets 118 and rf coil 120 are preferably housed in a non-magnetic section of the sub 30 that has axial slots 38 with a pressure barrier (not shown) of the invention.

With a non-magnetic sub 30, the static magnetic fields  $B_0$  from the permanent magnets 118 penetrate into the surrounding formation to excite the nuclei within the surrounding formation. The coil 120 in the RIT 10 provides a rf magnetic field  $B_1$ , which is perpendicular to  $B_0$  outside of the sub 30. The rf coil 120 is positioned in alignment with the axial slot(s) 38 in the sub 30.

A magnetic resonance measurement while tripping may be more complicated in comparison to propagation resistivity measurements due to various factors, including: an inherently lower signal-to-noise ratio, permanent magnet form factors, rf coil efficiency, high Q antenna tuning, high power demands, and a slower logging speed.

### 4.6.3 Gamma-Ray Measurement

It is known that gamma ray transport measurements through a formation can be used to determine its characteristics such as density. The interaction of gamma rays by Compton scattering is dependent only upon the number density of the scattering electrons. This in turn is directly proportional to the bulk density of the formation. Conventional logging tools have been implemented with detectors and a source of gamma rays whose primary mode of interaction is Compton scattering. See U.S. Pat. No. 5,250,806, assigned to the present assignee. Gamma ray formation measurements have also been implemented in LWT technology. See *Logging while tripping cuts time to run gamma ray*, OIL & GAS JOURNAL, June 1996, pp. 65-66. The present invention may be used to obtain gamma-ray measurements as known in the art, providing advantages over known implementations.

The subs 30 of the invention provide the structural integrity required for drilling operations while also providing a low-density channel for the passage of gamma rays. Turning to Figure 4b, this configuration is used to illustrate a gamma-ray implementation of the invention. In this implementation, a RIT 10 is equipped with a gamma-ray source and gamma-ray detectors (not shown) of the type known in the art and described in the '806 patent. The antennas 12 of Figure 4b would be replaced with a gamma-ray source and gamma-ray detectors (not shown).

Two gamma-ray detectors are typically used in this type of measurement. The gamma-ray detectors are placed on the RIT 10 at appropriate spacings from the source as known in the art. The slotted stations 36 are also appropriately placed to match the source and detector positions of the RIT 10. Calibration of the measurement may be required to account for the rays transmitted along the inside of the sub 30. The gamma-ray detectors may also be appropriately housed within the RIT 10 to shield them from direct radiation from the source as known in the art.

Turning to Figure 14, this configuration is used to illustrate another gamma-ray implementation of the invention. With the RIT 10 equipped with the described gamma-ray assembly and eccentered toward the slots 38, this configuration will capture the scattered gamma rays more efficiently and provide less transmission loss.

#### 4.6.4 Resistivity Measurement

The invention may be used to measure formation resistivity using electromagnetic propagation techniques as known in the art, including those described in U.S. Pat. Nos. 5,594,343 and 4,899,112 (both assigned to the present assignee). Figures 19a and 19b show two RIT 10 / sub 30 configurations of the invention. A pair of centrally located receiver antennas Rx are used to measure the phase shift and attenuation of EM waves. Look-up tables may be used to determine phase shift resistivity and attenuation resistivity. Transmitter antennas Tx are placed above and below the receiver antennas Rx, either in the configuration shown in Figure 19a, which has two symmetrically placed transmitter antennas Tx, or in the configuration shown in Figure 19b, which has several transmitter antennas Tx above and below the receiver antennas Rx. The architecture of Figure 19a can be used to make a borehole compensated phase-shift and attenuation resistivity measurement, while the multiple Tx spacings of Figure 19b can measure borehole compensated phase-shift and attenuation with multiple depths of investigation. It will be appreciated by those skilled in the art that other source/sensor configurations and algorithms or models may be used to make formation measurements and determine the formation characteristics.

#### 4.7 Inductively-Coupled RIT / Sub

Turning to Figure 20, other embodiments of a sub 30 and RIT 10 of the invention are shown. The sub 30 contains one or more integral antennas 12 mounted on the OD of the elongated body for transmitting and/or receiving electromagnetic energy. The antennas 12 are embedded in fiberglass epoxy, with a rubber over-molding as described above. The sub 30 also has one or more inductive couplers 122 distributed along its tubular wall.

The RIT 10 has a small-diameter pressure housing such as the one described above, which contains electronics, batteries, downhole processor, clocks, read-out port, recording memory, etc., and one or more inductive couplers 122 mounted along its body.

As shown in Figure 21, the RIT 10 is eccentric inside the sub 30 so that the inductive coupler(s) 122 in the RIT 10 and the inductive coupler(s) 122 in the sub 30 are in close proximity. The couplers 120 consist of windings formed around a ferrite body as

known in the art. Feed-throughs 124 connect the antenna 12 wires to the inductive coupler 122 located in a small pocket 126 in the sub 30. A metal shield 128 with vertical slots covers each antenna 12 to protect it from mechanical damage and provide the desired electromagnetic filtering properties as previously described. Correctly positioning the RIT 10  
 5 inside the sub 30 improves the efficiency of the inductive coupling. Positioning is accomplished using a stinger and landing shoe (See Figure 4a) to eccentric the RIT 10 within the sub 30. It will be appreciated by those skilled in the art that other eccentricing systems may be used to implement the invention.

As shown in Figure 22a, the inductive couplers 122 have "U" shaped cores made of  
 10 ferrite. The ferrite core and windings are potted in fiberglass-epoxy, over molded with rubber 131, and mounted within a coupler package 130 formed of metal. The coupler package 130 may be formed of stainless steel or a non-magnetic metal. Standard O-ring seals 132 placed around the inductive coupler package 130 provide a hydraulic seal. The inductive couplers 122 in the RIT 10 may also be potted in fiberglass-epoxy and over molded with rubber 131.  
 15 A thin cylindrical shield made of PEEK or PEK may also be placed on the OD of the sub 38 to protect and secure the coupler package 130 (not shown).

In operation, there will be a gap between the inductive couplers 122 in the RIT 10 and the sub 30, so the coupling will not be 100% efficient. To improve the coupling efficiency, and to lessen the effects of mis-alignment of the pole faces, it is desirable for the pole faces to  
 20 have as large a surface area as possible.

Figure 22b shows a 3.75-inch long by 1-inch wide slot 38 in the sub 30. The pole face for this inductive coupler 122 is 1.1-inches long by 0.75-inch wide, giving an overlap area of 0.825 square inches. This configuration maintains a high coupling efficiency and reduces the effects due to the following: movement of the RIT 10 during drilling or tripping, variations in the gap between the inductive couplers 122, and variations in the angle of the  
 25 RIT 10 with respect to the sub 30. Another advantage of a long slot 38 design is that it provides space for the pressure feed-throughs 124 in the inductive coupler package 130.

Antenna tuning elements (capacitors) may also be placed in this package 130 if needed. It will be appreciated by those skilled in the art that other aperture configurations



may be formed in the walls of the sub 30 to achieve the desired inductive coupling, such as the circular holes shown in Figure 20.

Since the pressure inside the sub 30 will be 1-2 Kpsi higher than outside the sub 30 in most cases, the inductive coupler package 130 should be mechanically held in place. Turning to Figure 23, the antenna shield 128 can be used to retain the inductive coupler package 130 in place. The shield 128 having slots over the antenna 12 as described above, but solid elsewhere. The solid portion retains the inductive coupler package 130 and takes the load from the differential pressure drop. Tabs may also be placed on the outside of the inductive coupler package 130 to keep it from moving inward (not shown). The shield 128 may also be threaded on its ID, with the threads engaging matching "dogs" on the sub 30 (not shown).

Figure 24 shows a simple circuit model for an embodiment of the inductive coupler and transmitter antenna of the invention. On the RIT 10 side, the current is  $I_1$ , and the voltage is  $V_1$ . On the sub 30 side, the current is  $I_2$  and the voltage is  $V_2$ . The mutual inductance is  $M$ , and the self-inductance of each half is  $L$ . This inductive coupler is symmetric with the same number of turns on each half. With the direction of  $I_2$  defined in Figure 24, the voltage and currents are related by  $V_1 = j\omega LI_1 + j\omega MI_2$  and  $V_2 = j\omega MI_1 + j\omega LI_2$ . The antenna impedance is primarily inductive ( $L_A$ ) with a small resistive part ( $R_A$ ),  $Z_A = R_A + j\omega L_A$ . Typically the inductive impedance is about  $100 \Omega$ , while the resistive impedance is about  $10 \Omega$ . A tuning capacitor ( $C$ ) may be used to cancel the antenna inductance, giving a RIT side impedance  $Z_2 = R_A + j\omega L_A - j/\omega C \sim R_A$ . The ratio of the current delivered to the antenna to the current driving the inductive coupler is  $I_2/I_1 = -j\omega M/(j\omega L + R_A + j\omega L_A - j/\omega C)$ . The inductive coupler has many turns and a high permeability core, so  $L \gg L_A$  and  $\omega L \gg R_A$ . To good approximation,  $I_2/I_1 \sim -M/L$  (the sign being relative to the direction of current flow in Figure 24).

#### 4.8 Implementations

As described above, the RIT 10 may be equipped with internal data storage means such as conventional memory and other forms of the kind well known in the art or subsequently developed. These storage means may be used to communicate data and/or instructions between the surface and the downhole RIT 10. Received signal data may be

stored downhole within the storage means and subsequently retrieved when the RIT 10 is returned to the surface. As known in the art, a computer (or other recording means) at the surface keeps track of time versus downhole position of the sub so that stored data can be correlated with a downhole location. Alternatively, the signal data and/or instructions may be communicated in real-time between the surface and the RIT 10 by LWD/MWD telemetry as known in the art (including EMAG telemetry).

Figure 25 illustrates a flow diagram of a method 300 for transmitting and/or receiving a signal through an earth formation in accord with the invention. The method comprises drilling a borehole through the earth formation with a drill string, the drill string including a sub having an elongated body with tubular walls and including at least one station having at least one slot formed therein, each at least one slot fully penetrating the tubular wall to provide a continuous channel for the passage of electromagnetic energy 305; engaging a run-in tool within the sub, the run-in tool being adapted with signal transmitting means and/or signal receiving means 310; locating the run-in tool within the sub such that at least one signal transmitting or receiving means is aligned with at least one slotted station on the sub 315; and transmitting or receiving a signal through the formation, respectively via the transmitting or receiving means 320.

Figure 26 illustrates a flow diagram of a method 400 for measuring a characteristic of an earth formation surrounding a borehole in accord with the invention. The method comprises adapting a downhole tool with at least one signal transmitting means and at least one signal receiving means 405; adapting the downhole tool with end means capable of accepting a fishing head or a cable connection 410; and with the fishing head on the tool, engaging the tool within a drill string to measure the formation characteristic, utilizing the transmitting and receiving means, as the drill string traverses the borehole; with the cable connection on the tool, connecting a cable to the tool and suspending the tool within the borehole to measure the formation characteristic utilizing the transmitting and receiving means 420.

The method 400 of Figure 26 may be implemented with the run-in tools 10 and subs 30 of the invention. The run-in tool may be configured with an end segment or cap (not shown) adapted to receive the previously described fishing head or a cable connection. With

the fishing head connected to the run-in tool, the tool may be used in accord with the disclosed implementations. With the cable connection, the run-in tool may be used as a memory-mode wireline tool.

It will be understood that the following methods for sealing an opening or slot on the surface of a tubular are based on the disclosed pressure barriers and slot inserts of the invention.

Figure 27 illustrates a flow diagram of a method 500 for sealing an opening on the surface of a tubular, wherein the tubular has an elongated body with tubular walls and a central bore. The method comprises placing an insert within the opening, the insert being formed in the shape of the opening 505; and applying a bonding material to the insert and/or opening to bond the insert within the opening 510.

Figure 28 illustrates a flow diagram of a method 600 for sealing a fully penetrating opening on the surface of a tubular having an elongated body with tubular walls and a central bore. The method comprises placing an insert within the opening, the insert being formed in the shape of the opening 605, and placing retainer means within the tubular to support the insert against the opening 610.

Figure 29 shows another embodiment of the invention. A RIT 10 is mounted inside a sub 30 equipped with internal centralizers 44 and a landing mechanism (not shown) as described above. As previously discussed, the RIT 10 may be equipped with density/neutron/PEF sources and sensors to make gamma-gamma formation density measurements through low-density walls in the sub 30, in which case the sub could be equipped with an external eccentricizer 43 to eccentric the sub 30 within the borehole. This configuration is particularly suited for TLC logging, where the sub 30 is conveyed into the well connected to coiled tubing or to another tubular (not shown). If used for TLC logging, the sub 30 may be configured with a sealed or open bottom end as desired.

#### 4.9 Antennas

The invention may also be implemented with an antenna providing a transverse or controllable magnetic dipole orientation. Figure 30 shows an antenna 45 consisting of two mutually perpendicular coils tilted at 45 degree angles each made up of 100 turns of 26 AWG

magnet wire disposed on the RIT 10 support. For such an antenna, it is easy to show that the effective TMD (LMD) turn area is equal to a LMD antenna of 200 turns of similar dimensions if the signals from the two tilted coils are combined such that the transverse (axial) components of their dipole moments add. By separately measuring the signals on each antenna, the antennas may be used to make both TMD and LMD measurements.

Figure 31 shows the antenna assembly 45 of Figure 30. For clarity of exposition, a transmitter antenna is considered here, however the basic principles are also true for a receiver. The two coils are used to excite and receive EM energy from all 3-D components. By connecting the two coils in series and forcing an alternating current into the assembly, a LMD or TMD can be generated. If we assign a polarity to each coil denoted by a + -, connecting the two coils in series as (+ -) (+ -) will generate one type of magnetic dipole orientation, for instance a LMD, while connecting the two coils as (+ -) (- +) will be equivalent to a TMD. The receiver assembly will be identical to the transmitter assembly.

If we denote the induced voltages in the first and second coil as  $V_1$  and  $V_2$ ,  $V_1 + V_2$  will represent the vertical component of the induced magnetic field, while  $V_1 - V_2$  will represent the horizontal component of the induced magnetic field. In LWD applications, with the sonde being rotated, the preceding antenna assembly will be sufficient to probe the field components in 3-D. For wireline applications, an identical antenna assembly may be mounted on the support with an azimuth of 90 degrees with respect to the first coil assembly as shown in Figure 32.

The same antenna 45 may be used to produce an equivalent magnetic field with any orientation. If we combine the voltage difference ( $V_{11} - V_{21}$ ) as a vector sum when the excitation current is  $I_1$  with the voltage difference ( $V_{21} - V_{22}$ ) when the excitation current is  $I_2$ , we get:

$$V_{11} + V_{12} = (K_{11} + K_{12}) I_1$$

and

$$V_{21} + V_{22} = (K_{21} + K_{22}) I_2$$

$$V = \sqrt{(K_{11} + K_{12})^2 I_1^2 + (K_{21} - K_{12})^2 I_2^2}.$$

The condition  $I_1 = I_2$ , is equivalent to a magnetic dipole inclined by 45 degrees. With this configuration, the antenna produces a controllable field pattern. Thus if desired, a TMD may be generated. While a two-coil antenna is shown, it will be understood by those skilled in the art that the invention may be implemented with other antenna configurations. For example, the antenna may consist of a plurality of co-wound coils, such as a tri-axial configuration, or saddle-coils, or flex-circuit (not shown) configurations as known in the art.

Figures 33a-33c show other antenna assemblies 45 of the invention which comprise one or more saddle coils. Turning to Figure 33a, an antenna 45 is illustrated having segmented coils 602 and 604. These segmented coils together produce a magnetic dipole 608 that extends radially from the support (represented by the dashed line). As is generally illustrated, the segmented coils 602, 604 are formed to extend about the circumference of the support. This system is referred to as a saddle coil because its shape resembles that of a saddle. It consists of a circular arc at the top and bottom of the coil connected by a longitudinal segment. A pair of these coils is often disposed on azimuthally opposite sides of the support member. The coil segments 602, 604 may be connected in series to insure equal current parameters, or they may be connected in parallel if desired. Alternatively, the segmented coils 602, 604 may be independently disposed on the support and energized to produce the magnetic dipole.

Turning to Figure 33b, which is an axial view of the tool, another antenna 45 embodiment includes a second set of half-coils 622, 624 that orient and receive current so as to produce a magnetic dipole 628 that also extends radially from the support on which the half-coils are mounted. Half-coils 602 and 604 are overlaid to surround half-coils 622 and 624. The half-coils 622, 624 are disposed on the support to produce the magnetic dipole 628 so that dipole 628 is rotated azimuthally with respect to the magnetic dipole 608. The design of half-coils 622 and 624 is similar to the design of half-coils 602 and 604, however they are rotated azimuthally with respect to the previous set. Figure 33c further illustrates the orientation of these magnetic dipoles 608, 628. These magnetic dipoles 608 and 628, disposed within the borehole 630, are controllable so that the measurement sensitivity may be directed axially from the support at any azimuth angle.

Regardless of the antenna configuration disposed on the RIT 10, the antenna may be protected from damage by an external shield 26 as described above. Since the shield 26 has relaxed mechanical requirements, it could be made of a strong dielectric material such as PEK, PEEK, KEVLAR, or any other suitable compound. The shield 26 may be configured with multiple slots as described above and shown in Figure 2b. The shield 26 may also be configured with a combination of axial (vertical) and transverse (horizontal) slots (not shown). Alternatively, the RIT 10 may also be implemented with shields having angled slots or strip shield configurations as described in U.S. Pat. No. 6,297,639 (assigned to the present assignee). Such shields allow for very low attenuation of both LMD and TMD fields.

#### 4.10 LMD / TMD Implementations

It has been determined that the coupling between a LMD and TMD transmitter-receiver pair (LMD-TMD) has an approximately cosine directionality that can provide valuable additional information for directional drilling and “geosteering” in horizontal wells. A LMD-TMD equipped RIT 10 will provide a low-cost directional deep measurement that can distinguish whether the well trajectory is approaching the roof or floor of a reservoir, providing more information on the structure of and fluid flows in reservoirs than traditional LMD measurements.

Modeling has shown that a sub 30 configured with axial slots permits the transmission of transverse dipole magnetic fields, with some attenuation of the TE field as described above. Figure 34 shows another embodiment of the invention. The sub 30 is configured with two axial slots 38 and the RIT 10 is equipped with a TMD antenna 45 to create/receive a TMD field through the sub 30. The antenna 45 may be any TMD configuration, such as those described above. The dipole moment of the antenna 45 is preferably aligned with the slots 38. Figure 35 shows another embodiment of the invention. In this case two coils are co-wound with their dipole moments perpendicular to each other, each in alignment with the slots 38. Alternatively, a tri-axial, saddle-coil, or flex-circuit antenna assembly may be used with the invention.

Figure 36 shows the magnetic field attenuation of a single TMD antenna in a sub of the invention configured with two axial slots. The field attenuation is ~5 dB for 1” wide

slots, and ~8.5 dB for 0.5" wide slots away from the sub. This is less attenuation than for a comparable LMD antenna. The attenuation data show the expected distortion of the field near the sub: the field attenuation decreases near the slot and increases away from it.

That the attenuation of the TMD fields through the axial slots is less than for LMD fields implies that the tilt angle of the far field from a single tilted-coil antenna inside the sub would increase compared to that expected from the naked coil (i.e., the physical tilt angle of the coil). Indeed, modeling shows this to be the case. Figure 37 shows the EM field rotation from a tilted-coil antenna in  $x$  and  $y$  directions ( $x$ - $y$  plane) of the plane (tool axis  $z = 0$ ), with and without the sub. Presence of the slotted sub 30 increases the field tilt angle from 45 degrees to about 70 degrees. It is noted that although this provides a way to produce a "tilted dipole" antenna through a tubular, the amount of tilt is dependent on factors such as the resistivity surrounding the tubular and on the frequency of operation.

Figure 38 shows a TMD-equipped embodiment of the invention. A TMD receiver is incorporated into the RIT 10. The RIT 10 may be equipped with an oriented stinger (not shown) to orient the TMD antenna so that its moment is aligned with the plane of the slots. In LWD operation, each LMD transmitter is fired in turn and the complex TMD receiver voltage is measured as the RIT 10 rotates to provide a multi-depth directionally sensitive measurement. The roll angle (with respect to up/down) can be determined using a combination of magnetometers and accelerometers as known in the art and described in U.S. Pat. No. 5,513,528 (assigned to the present assignee).

Figure 39 shows another embodiment of the invention. A RIT 10 is implemented with at least one dual TMD/LMD transmitter and TMD receiver in addition to the LMD propagation resistivity array. This arrangement provides TMD-TMD measurements, which have sensitivity to formation anisotropy. The RIT 10 may also be configured with more LMD and TMD antennas than sub slot stations. These extra antennas would be useless for LWT or LWD applications, but could provide more measurements if the RIT is used independently in wireline mode.

Figure 40 illustrates a flow diagram of a method 700 for determining a property of a subsurface formation in accord with the invention. The method comprises disposing an elongated body within a borehole traversing said formation, said body having tubular walls, a

central bore, and including at least one slot formed therein such that the slot fully penetrates the tubular wall 705; disposing a support within the central bore of said body, said support having a longitudinal axis and at least one antenna disposed thereon, said antenna being adapted to generate a magnetic dipole moment with a transverse or controllable orientation 5 710; positioning said antenna near the at least one slot on said body 715; and transmitting or receiving a signal with said at least one antenna to determine said formation property 720.

#### 4.11 Through collar TMD in water-based muds

Simulation has shown that transmission of TMD fields through an axial slot in a 10 tubular is significantly reduced in water-based mud. The TMD field generates reaction currents in the mud that close on the metal of the tubular. One way of eliminating these currents is by insulating the tubular.

Figures 41a-41c show other embodiments of the invention. A TMD equipped RIT 10 is mounted inside a sub 30 that has two symmetrical axial slots 38. A nonconducting sleeve 15 52 inside the sub 30 hydraulically seals the sub and also prevents currents that close on the inner diameter of the sub. The nonconducting sleeve 52 may be formed and implemented in accordance with the pressure barrier described above. A nonconducting shield 47 is also mounted over the outside of the sub 30, covering the slots and preventing reaction currents that close on the outside of the sub. The exterior shield 47 may also be configured to form a 20 hydraulic seal if desired, but it is not necessary for operation of the invention. The exterior shield 47 may be formed of fiberglass-epoxy, PEK, PEEK, KEVLAR, or any other suitable material or compound. The exterior shield 47 may also be protected and held in place by wear bands 49.

While the methods and apparatus of this invention have been described as specific 25 embodiments, it will be apparent to those skilled in the art that other embodiments can be readily devised which do not depart from the concept and scope of the invention as disclosed herein. For example, a sub of the invention may be configured with slots that are angled with respect to the sub axis or transverse to the sub axis (not shown). All such similar variations apparent to those skilled in the art are deemed to be within the scope of the invention as 30 defined by the appended claims.